Work Order ID 51273

August 13, 2009 10:54:44 AM

Item ID: D205-634-041 **Accept** **Setup Start**

Revision ID: D **Stop**

Item Name: Replacement Skidtube

Start Date: 8/13/09 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 10/13/09 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** CL MP **Date:** 09/08/13 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2580	Rev D								
100		0.00							
DC	DOCUMENT CONTROL								
Document Control	**Memo**	0.00							
	Photocopy D205-634 bluefile & type labels per PPP D205-634-041				CHG002				
110		0.00							
CNC Bend 1	BENDING MACHINE - SKIDTUBES								
CNC Delta 100 Bender	**Memo**	0.00							
	1-Bend as per program D2580.C on CNC Bender and Folio FT009								
	2-Cut tubes as per Dwg. D2580								

N/A

D

N 9-8-17

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
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NOTE: Date & initial all entries

Work Order ID 51273

August 13, 2009 10:54:44 AM

Item ID: D205-634-041 **Accept** **Setup Start** **Stop**

Revision ID: D

Item Name: Replacement Skidtube

Start Date: 8/13/09 **Start Qty:** 1.00 **Cust Item ID:**

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00				1	0	- AVM 9-8-17	
Skidtubes	**Memo**	0.00							
Skidtubes	1- Deburr ends 2- C'sink holes as per dwg without cutting fluid 3- Prepare tube for welding, remove alodine as required. 4- Scribe batch number insied aft end of tube.								
130	QC5- Inspect part completeness to step on W/O	0.00				2)	0	8/8/17	
QC	**Memo**	0.00							
Quality Control									

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W/O:		WORK ORDER CHANGES					
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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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QC: _____ _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
Skidtubes									
Skidtubes	**Memo**	0.00							

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod m110295 BE 09/08/20

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.
For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R□□□ Aluminum Rod m110295 BE 09/08/20

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web.Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

- AWME-8-24

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W/O:		WORK ORDER CHANGES					
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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC10- Inspect visual per QSI004- ground welds **Memo**	0.00 0.00	=> 8/12/26			X0	0		
160 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	=> 8/12/26			X0	0		
170 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 **Memo**	0.00 0.00	MD 8/10/27			X1			

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	**Memo** M112260	0.00	=> W 09/08/27			1	0		
Powder Coating	START TIME: 2:00pm OVEN TEMPERATURE: 320°F FINISH TIME: 2:30pm								
190	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00	BK 09-09-01.		D				
Quality Control									

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200		0.00							
HandFinish	**Memo**	0.00							
Hand Finishing									

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐☐☐ Sikaflex-291 ☐ M11834[illegible]
Sikaflex expire date: 10/20

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐☐ Sikaflex-291 ☐ M11123[illegible]
Sikaflex expire date: 10/20

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: M110406

AP 09109/01 X1

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W/O:		WORK ORDER CHANGES					
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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Work Order ID 51273

August 13, 2009 10:54:44 AM

Item ID: D205-634-041 **Accept** **Setup Start** **Stop**

Revision ID: D

Item Name: Replacement Skidtube

Start Date: 8/13/09 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 10/13/09 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control	Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024								
220	Packaging	0.00							
Packaging	**Memo**	0.00							
Packaging	Identify and pack for shipping as per PPPD205-634-041 Location:_____ PPP Rev:_____								
230	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

51273

CL09109130

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

August 13, 2009 10:54:43 AM

Work Order ID: 51273

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09 **Required Date:** 10/13/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2580-1RevD		Manufactured	No			110	Each	8.0000	1.0000			
205 Skidtube bent detail												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
LG	6	
50757	6	
Main Warehouse		
ST	2	
50758	2	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2576-3RevG		Manufactured	No			140	Each	147.0000	1.0000			
Step (maching detail)												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	147	
43504	46	
46661	101	

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

August 13, 2009 10:54:44 AM

Work Order ID: 51273

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09 **Required Date:** 10/13/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2579RevE		Manufactured	No			140	Each	92.0000	20.0000			
Crossbolt Spacer												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	92	
43988	4	
46434	4	
46956	2	
47797	28	
48272	54	

20 B51314 BE 09/08/20

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2855RevA		Manufactured	No			200	Each	37.0000	1.0000			
Cap												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
FP6	37	
50513	37	

X1 MI 09/09/01

Dart Aerospace Ltd

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Work Order ID: 51273

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09 **Required Date:** 10/13/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-5A		Purchased	No			200	Each	2,540.000	2.0000			
Bolt												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	2540	
100188	226	
105057	2246	
15205	68	

x2 MH 09109101

AN960JD10L		Purchased	No			200	Each	6,733.000	2.0000			
Washer												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	6733	
101291	16	
104885	153	
105793	236	
109632	1328	
110985	5000	

x2 MH 09109101

Dart Aerospace Ltd

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Comments:

Start Date: 8/13/09 **Required Date:** 10/13/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-130		Purchased	No			200	Each	3,628.000	50.0000			
Insert												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	3628	
105855	16	
108606	52	
111529	1560	
111779	2000	

x50 MH 09/09/07

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C4A		Purchased	No			200	Each	1,222.000	50.0000			
BOLT												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	1222	
112082	40	
112314	1182	

x30 MH 09/09/07

Dart Aerospace Ltd

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Parent Item Name: Replacement Skidtube

Comments:

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Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L		Purchased	No			200	Each	3,764.000	50.0000			
washer												

Warehouse Location	Loc Qty	Loc Code
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	3664	
112116	3664	

x 50 09/09/01

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-13RevC *		Manufactured	No			200	Each	29.0000	1.0000			
Gasket												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	29	
45717	1	
46889	2	
48166	10	
50265	16	

~~B51259~~ [redacted]

x1 09/09/01

Dart Aerospace Ltd

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Comments:

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Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-5RevC Gasket		Manufactured	No			200	Each	4.0000	1.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	4	
36113	1	
46186	1	
47318	1	
48167	1	

B51260 XI AP 09/09/01

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-1RevC Gasket		Manufactured	No			200	Each	13.0000	2.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	13	
46349	1	
47434	2	
48557	3	
51218	7	

B51259 XI AP 09/09/01

Dart Aerospace Ltd

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Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09 **Required Date:** 10/13/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-11RevD		Manufactured	No			200	Each	15.0000	1.0000			
Wearshoe												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse	13 5 4 256	
ST	15	
45823	1	
48553	4	
50112	10	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-13RevD		Manufactured	No			200	Each	39.0000	1.0000			
Wearshoe												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
FP17	24	
48554	2	
50270	22	
Main Warehouse		
ST	15	
45409	3	
46495	10	
47867	2	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

August 13, 2009 10:54:44 AM

Work Order ID: 51273

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09 **Required Date:** 10/13/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-9RevD		Manufactured	No			200	Each	3.0000	1.0000			
Wearshoe												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse	B51258		x1	11 09/09/0(
ST	3			
44659	1			
45825	1			
48556	1			

D3564-5RevD		Manufactured	No			200	Each	6.0000	1.0000			
Wearshoe												

Warehouse Location	Loc Qty	Loc Code		
OFFSHORE	B51257		x1	11 09/09/01
FG	2			
34806	2			
Main Warehouse				
FP19	2			
48555	2			
Main Warehouse				
ST	2			
45824	1			
47433	1			

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

August 13, 2009 10:54:44 AM

Work Order ID: 51273

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09 **Required Date:** 10/13/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-3RevC		Manufactured	No			200	Each	670.0000	16.0000			
O-Ring, 205 Skidtube												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	670	
27168	44	
29908	626	

D2594-1RevC		Manufactured	No			200	Each	476.0000	16.0000			
Plug, 205 Skidtube												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	476	
42221	16	
42807	92	
43884	3	
46435	2	
47251	363	

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2580 REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY SCALE NTS

A	96.09.16	NEW ISSUE
B	96.12.02	AS MANUFACTURED
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183

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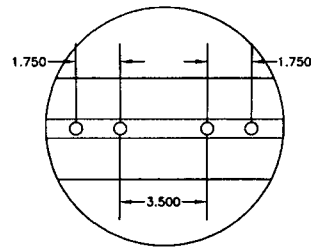
QTY -041	QTY -045	Part Number	Description
X		**D2580-041**	**SKIDTUBE ASSEMBLY**
	X	**D2580-045**	**SKIDTUBE ASSEMBLY**
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2) ALL DIMENSIONS ARE IN INCHES
3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
6) WELDING TO BE DONE PER DART QSI 004.
7) FINISH:
 SEE NOTES ON
 PAGE 2 FOR D2580-041 AND
 PAGE 3 FOR D2580-045
8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

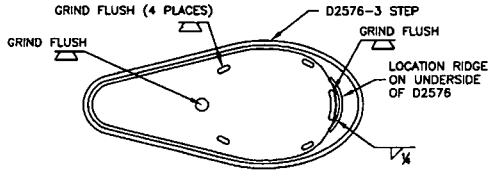
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DETAIL A
SCALE 5:24

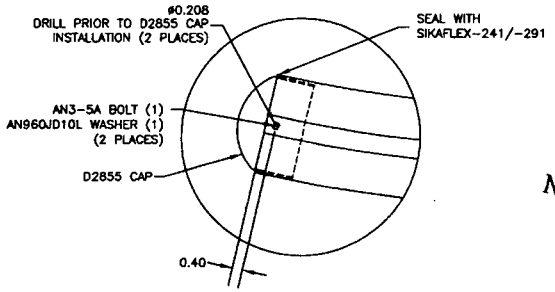


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DETAIL B
SCALE 5:24

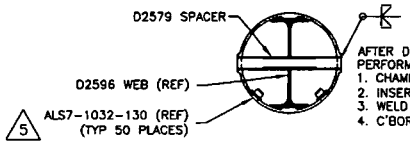


DETAIL C
SCALE 5:24



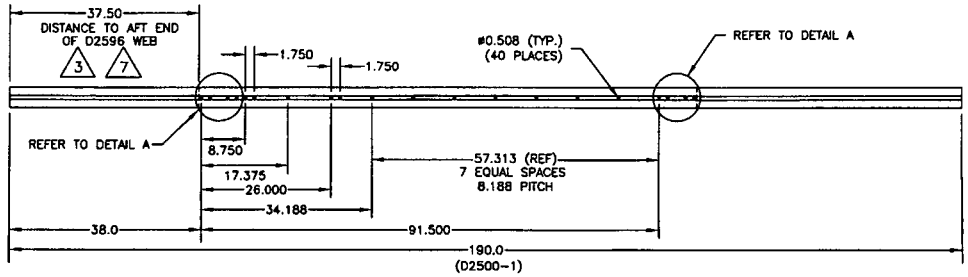
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SECTION D-D
SCALE 5:24

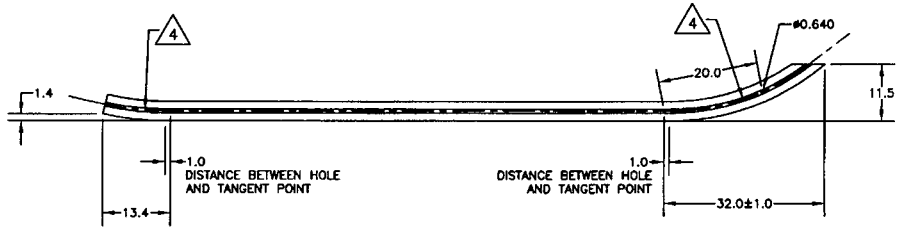


AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO ø0.437 X 1.00 DEEP

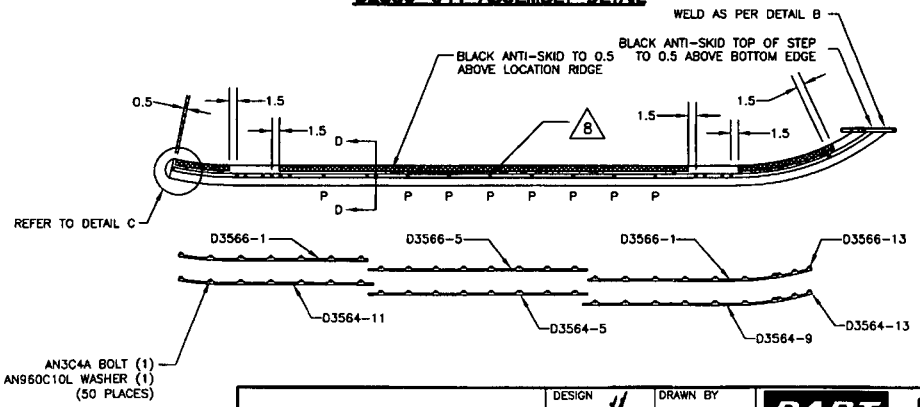
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



D2580-041 NOTES

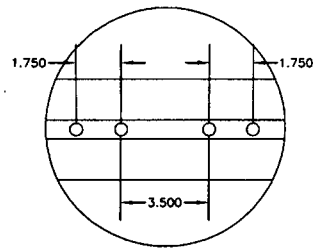
i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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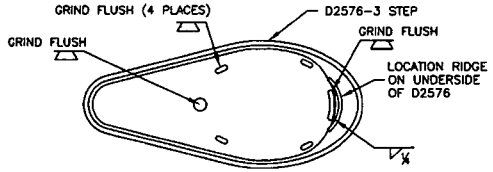
DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2580 — REV. D — SHEET 2 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY — SCALE 1:24

DETAIL E
SCALE 5:24

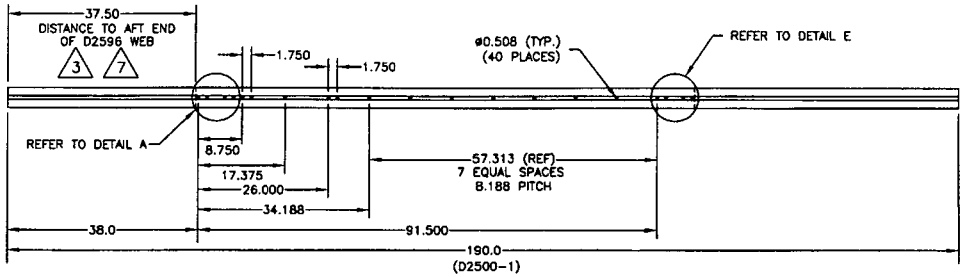


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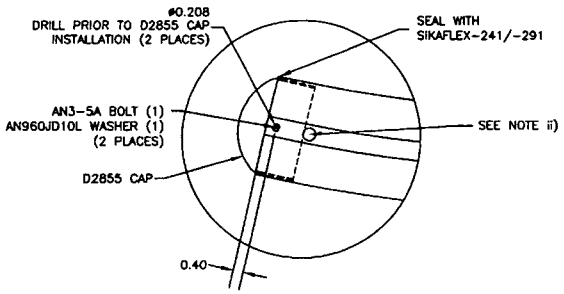
DETAIL F
SCALE 5:24



D2580-1 DRILLING DETAIL

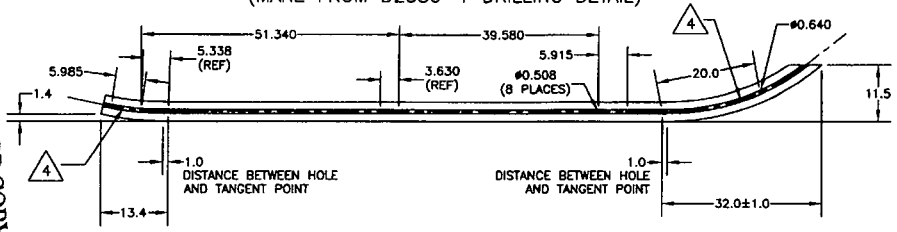


DETAIL G
SCALE 5:24

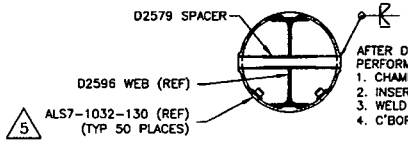


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D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)

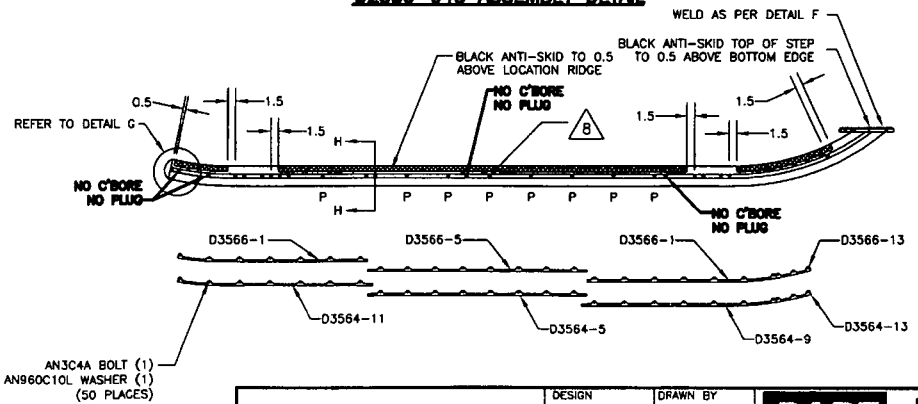


SECTION H-H
SCALE 5:24



AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO ø0.437 X 1.00 DEEP

D2580-045 ASSEMBLY DETAIL



C

D2580-045 NOTES

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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CHECKED	APPROVED	DRAWING NO. D2580 — REV. D — SHEET 3 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY — SCALE 1:24

NO. 206

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 50849
Part number: D205 634 041
Description: 205 skid tube
Welding Process: Tig[✓] Mig[]
Base materiel: Aluminium
Current: AC[✓] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[✓] fail[]
Penetration:	pass[] fail[]

UNACCEPTABLE

Cracks:	pass[] fail[]
Undercut:	pass[] fail[]
Pin holes:	pass[✓] fail[]
Overlap (cold lap)	pass[] fail[]
Porosity (surface):	pass[] fail[]
Coloration:	pass[✓] fail[]

Qualifier [signature] **Date of Test Coupon** 09.08.13

Welder Barclay Elliott **Date of Test Coupon** 09.08.13

The above named individual is qualified in accordance with AWS D17.1.2001 to weld